

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004878**Date Inspected:** 24-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	OBG-Floor Beam OBG	NA	NA	QA-UT

Bay 8: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001479. The subassembly is identified as floor beam; weld FB061-001-095. Caltrans QA inspector observed that the weld has been UT inspected and identified as accepted by ZPMC QC. Caltrans QA-UT coverage was approximately 10%. The weld was found to be in conformance with the project specifications. However, ZPMC QC-UT inspector rejected weld FB061-001-096 for weld defects. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 24, 2008 for additional information.

2	OBG-Floor Beam OBG	NA	NA	QA-MT
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Bay 8: Caltrans QA inspector performed magnetic particle test (MT) inspection per ZPMC notification of witness inspection, document number 001479. The subassembly is identified as floor beam; welds FB005-017-023, FB005-017-025, FB005-017-029, FB005-017-029, FB005-017-030, FB005-017-037 and FB005-017-038. Caltrans QA inspector observed that the welds have been MT inspected and accepted by ZPMC QC. Caltrans QA-MT coverage was approximately 10%. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated, November 24, 2008 for additional information.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, 150-0219-9593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler,Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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